



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

(4)

D3391-025
Job Sheet 185029



Part No: D3391-025

Job Qty: 1 ea

Part Name: Aft Tube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/23/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV J SHEETS 9,10,11 IPP Rev B 06-02-07 ECN773 dwg rev. D EC IPP Rev:C 06-03-28 Update
Manuf. Instructions JLM IPP rev D 07.03.20 revF dwg EC IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified
by: DD IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC IPP Rev:G 08-09-10 revH as per dwg DD verified
by:EC IPP Rev:H 11.11.14 AS PER REV.I DD verified by:JLM

Ship Via:

Bill of Materials



Container No: S122063



Part: D3391 - 025

Job No: 185029

Serial No/Batch: S122063

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/28/18

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/23/18	0.00	0.00	Start Up Crosstubes		MD 2018-10-28
100	Mori Seiki	1 pcs		11/23/18	2.49	4.17	Mori Seiki TL-40		MD 2018-10-28
110	QC	1 pcs		11/23/18	0.00	0.00	QC2-1		MD 2018-10-28 DAS 38
112	QC	1 pcs		11/23/18	0.00	0.00	QC5		MD 2018-10-28
120	CNC Vertical Machining	1 pcs		11/23/18	0.00	2.63	HAAS1-3		MD 2018-11-27
130	QC	1 pcs		11/23/18	0.00	0.00	QC2 Machining-2		MD 2018-11-27
140	QC	1 pcs		11/23/18	0.00	0.00	QC8 Machining-2		MD 2018-11-28
150	Skidtubes	1 pcs		11/23/18	0.00	1.03	Skidtubes-4		MD 2018-11-28
160	CNC Bend Skidtubes	1 pcs		11/23/18	0.00	1.33	CNC Bend Skidtube		MD 2018-11-28
170	QC	1 pcs		11/23/18	0.00	0.00	QC5		MD 2018-11-28
180	Skidtubes	1 pcs		11/23/18	0.00	1.03	Skidtubes-4		MD 2018-11-28
190	QC	1 pcs		11/23/18	0.00	0.00	QC5		MD 2018-11-28
200	HandFinish	1 pcs		11/23/18	0.00	0.58	HandFinish1		MD 2018-11-28
210	QC	1 pcs		11/23/18	0.00	0.00	QC7-2		MD 2018-11-28
220	Skidtubes	1 pcs		11/23/18	0.00	1.41	Skidtubes-4		MD 2018-11-28
230	QC	1 pcs		11/23/18	0.00	0.00	QC5		MD 2018-11-28
235	HandFinish	1 pcs		11/23/18	0.00	0.58	HandFinish2		MD 2018-11-28
240	SprayPaint	1 pcs		11/23/18	0.00	0.25	Spray Paint		MD 2018-11-28
242	Outsource	1 pcs		11/23/18			ATE003-VC		MD 2018-11-28
250	QC	1 pcs		11/23/18	0.00	0.00	QC14		MD 2018-11-28
260	HandFinish	1 pcs		11/23/18	0.00	0.58	HandFinish4		MD 2018-11-28
270	QC	1 pcs		11/23/18	0.00	0.00	QC5		MD 2018-11-28
280	Packaging	1 pcs		11/23/18	0.00	0.00	Packaging3-1		MD 2018-11-28
290	QC21-SA	1 Ea		11/23/18	0.00	0.00	QC21		MD 2018-11-28

Part Op 100 - Turn as per Folio FA599 Rev: J & Dwg D3391 Rev: J ***ensure steady rest is turning true*** REMOVE
 Descriptions: STEADY REST AND MACHINIG MARKS****

120 - 1-Machine as per Folio FA 599 Rev: J & Dwg D3391 Rev: J

140 - ***INSPECT INSIDE BORE***

150 - 1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

160 - Form as per Dwg D3391 Using Bend Prog 3391025

180 - 1-Open Aft cap pilot hole to .208" as per Dwg D3391 2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only. 3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig . *****Do Not Open To Finished Size***** 4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes. 5-Open wearplate holes to 0.297" and c'bore as per dwg D3391 6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391. 8- Scribe batch # on fwd end

220 - 1- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: 5080785 exp. date : 19/05/01 cure time 12hrs as per QSI0015 2- Grind crossbolts flush 3- Back drill using #9 drill 4- Touchup Magnabond 5- Deburr

235 - AND REALODINE AS PER PAR09-043

240 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 Primer 13888 Paint 138978

260 - 1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 A/ R Sikaflex-241/-291 14039 9.9.1 Sikaflex expiry date: 19-3 3- INSTALL WEARPLATES AS PER DWG

290 - 5- Detail DD, open (5) forward wearplate holes 0.375", then use DT10247 and drill holes for nutplates and c'sink. 6- Open wearplate holes to 0.297" and c'bore as per dwg D3391. ***SIX FARTHEST AFT HOLES ONLY*** 7-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391. 8-Deburr 9- Scribe batch # on fwd end

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DEC 6 3 2018

B134427

Job BOM

C06804

Part / Item	Component Name	Quantity	Operation	Container
D6014-090	Aluminum Extrusion	1 Ea (1 ea)	90-Start up Operation	
D3670-4-200	Bushing	4 Ea (4 ea)	220-Skidtubes	5123086
ALS4-1032-130	Rivnut	8 Ea (8 ea)	260-HandFinish	5007279
ALS4-1032-225	Rivnut	4 Ea (4 ea)	260-HandFinish	5058132
AN3C4A	Bolt	6 Ea (6 ea)	260-HandFinish	5095223
AN3C5A	Bolt	4 Ea (4 ea)	260-HandFinish	5095214
D2646	Aft Cap	1 Ea (1 ea)	260-HandFinish	M163254-102
D3672-1	Washer, Phenolic	2 Ea (2 ea)	260-HandFinish	F164009
D4095-047	Wearpad Aft	1 Ea (1 ea)	260-HandFinish	5070710
D4095-049	Wearpad Aft	1 Ea (1 ea)	260-HandFinish	5003289
MS20601-AD4W3	Rivet	12 Ea (12 ea)+9	260-HandFinish	5092687
MS20601-AD4W7	Rivet	8 Ea (8 ea)	260-HandFinish	M137148
MS21075L5	Nut Plate	10 Ea (10 ea)+3	260-HandFinish	5093726
NAS1149C0332R	Washer	10 Ea (10 ea)	260-HandFinish	5089463

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6014-090	1	9	0
220-Skidtubes	D3670-4-200	4	43	0
260-HandFinish	ALS4-1032-130	8	11,813	0
	ALS4-1032-225	4	1,815	0
	AN3C4A	6	2,094	0
	AN3C5A	4	1,694	0
	D2646	1	63	0
	D3672-1	2	956	0
	D4095-047	1	21	0
	D4095-049	1	30	0
	MS20601-AD4W3	12	624	0
	MS20601-AD4W7	8	121	0
	MS21075L5	10	304	0
	NAS1149C0332R	10	3,690	0

Part Specifications

Specifications could not be found.

Plex 10/22/18 9:14 AM dart.white.jesse

④

DART AEROSPACE LTD		Work Order: 185029
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	✓		Tape	
3.500	+/-0.010	3.497	✓		CNC-08	
Ø3.200	+/-0.010	3.205	✓		CNC-05	
Ø3.750	+/-0.010	3.753	✓		CNC-05	
30° x 0.060 chamfer	+/-0.010	.067	✓		CNC-08	
88.93	+/-0.030	88.92	✓		Tape	

Measured by: MD	Date: 2018/10/28
Audited by:	Date:

HAAS Section						
1.526	+0.000/-0.030	1.506	✓		Vern.	
7.500	+/-0.010	7.497	✓		Vern.	
27.750	+/-0.010	27.752	✓		Dial	
31.750	+/-0.010	31.7515	✓		Dial	
35.250	+/-0.010	35.252	✓		Dial	
3.300	+/-0.010	3.294	✓		Vern.	
0.200	+/-0.010	0.202	✓		Vern.	
3.520	+/-0.010	3.518	✓		Micro M	
0.687	+0.010/-0.000	0.688	✓		Vern.	
R0.062	+/-0.010	0.062	✓		R.G.	
Ø0.484	+0.005/-0.001	0.485	✓		G.P.	

Measured by: JIP 18-11-27	Date:
Audited by: KJ	Date: 18-11-28

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	
M	16.06.23	Dimensions updated per Rev J	KJ	

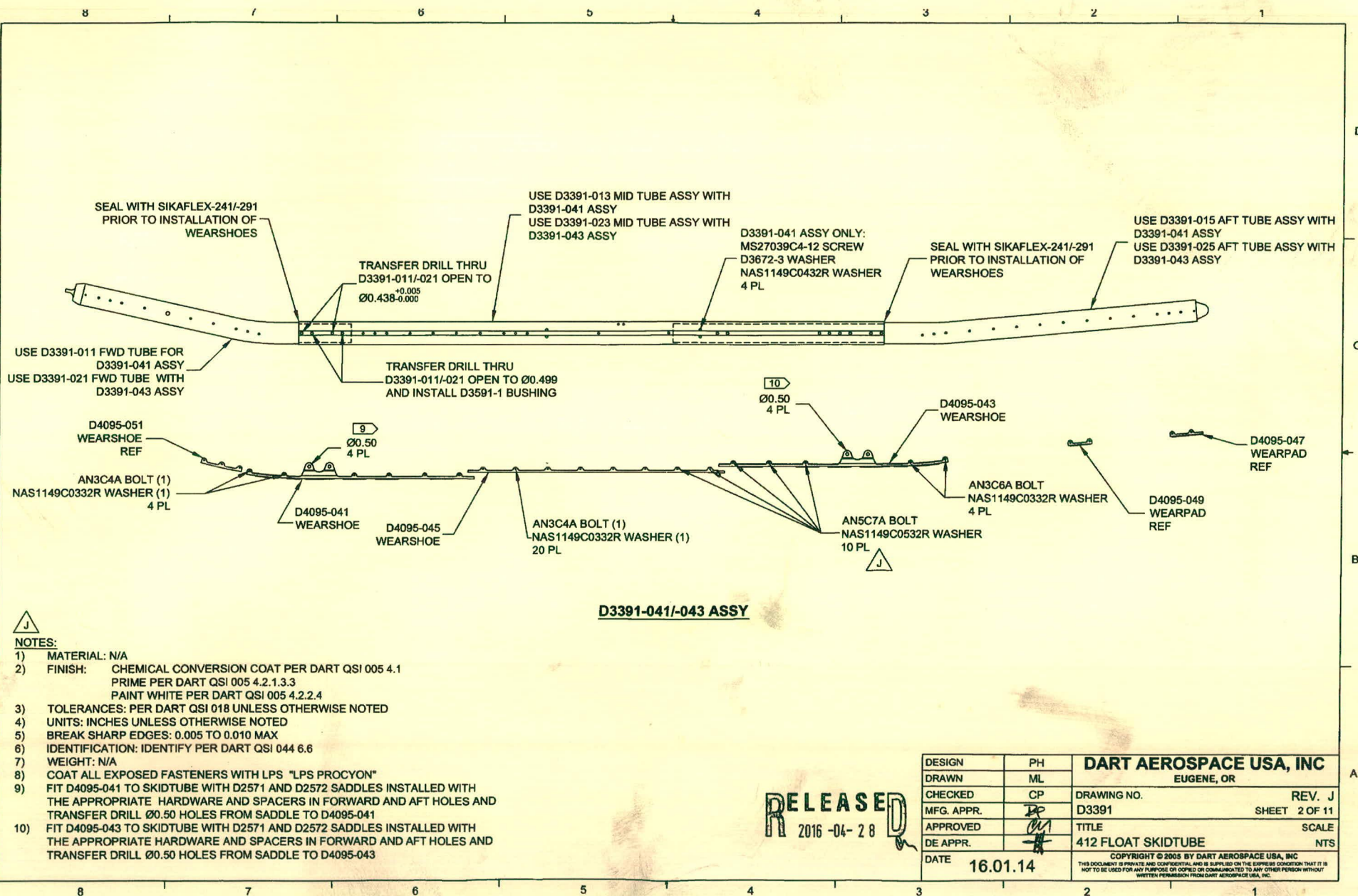
D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3391-041	FLOAT SKIDTUBE ASSEMBLY
	X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
2	2	D3591-1	BUSHING
4		D3672-3	WASHER
1	1	D4095-041	WEARSHOE
1	1	D4095-043	WEARSHOE
1	1	D4095-045	WEARSHOE
1	1	D4095-047	WEARPAD
1	1	D4095-049	WEARPAD
1	1	D4095-051	WEARSHOE
24	24	AN3C4A	BOLT
4	4	AN3C6A	BOLT
10	10	AN5C7A	BOLT
28	28	NAS1149C0332R	WASHER
10	10	NAS1149C0532R	WASHER
4		MS27039C4-12	SCREW
4		NAS1149C0432R	WASHER

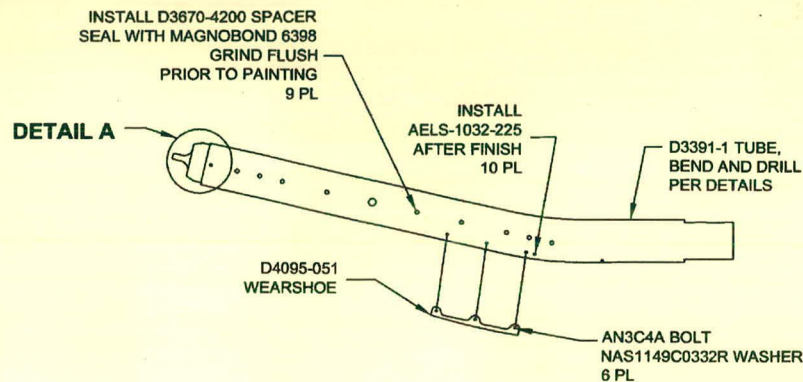
J

J	INCORPORATED DSI 9733, REFORMAT DRAWING CHANGED CBORE DEPTH (ZN D2-8, D2-9), REVISED TABLES, REPLACED POWDER COAT WITH PAINT	ML	16.01.14
I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	08.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	08.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV.
MFG. APPR.	DP	D3391	SHEET 1 OF 11
APPROVED	EP	TITLE	SCALE
DE APPR.	EP	412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

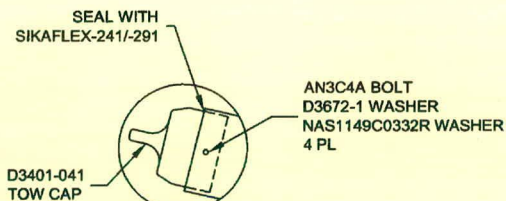
RELEASED
2016-04-28
ECN 16-516







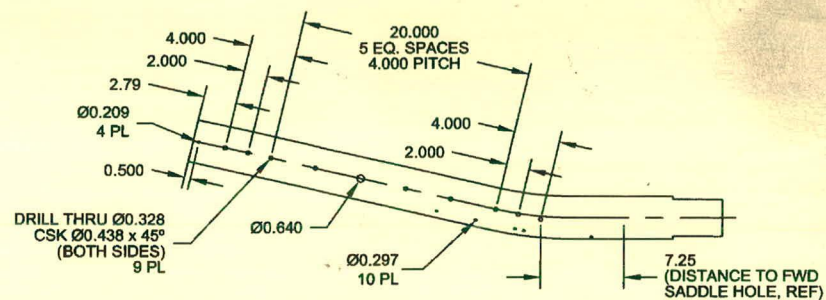
D3391-011 FWD TUBE ASSEMBLY
ASSEMBLY DETAIL



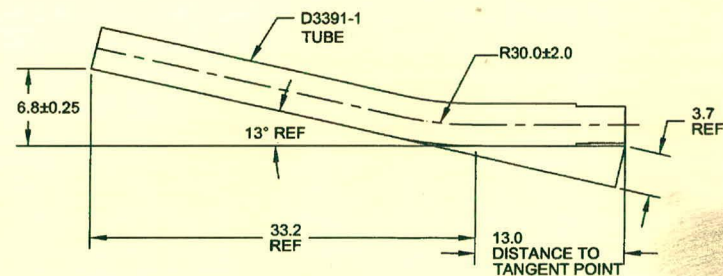
DETAIL A
SCALE 2X

D3391-011 FWD TUBE ASSEMBLY PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	D3391-011	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
9	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER



D3391-011 DRILLING DETAIL



D3391-011 BENDING DETAIL
(MAKE FROM D3391-1)

RELEASED
2016-04-28

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	<i>Pr</i>	D3391	SHEET 3 OF 11
APPROVED	<i>Ch</i>	TITLE	SCALE
DE APPR.	<i>Ch</i>	412 FLOAT SKIDTUBE NTS	
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INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
4 PL

DETAIL B



INSTALL
AELS-1032-225
AFTER FINISH
10 PL

D4095-051
WEARSHOE

AN3C4A BOLT
NAS1149C0332R WASHER
6 PL

D3391-021 FWD TUBE ASSEMBLY ASSEMBLY DETAIL

SEAL WITH
SIKAFLEX-241/-291



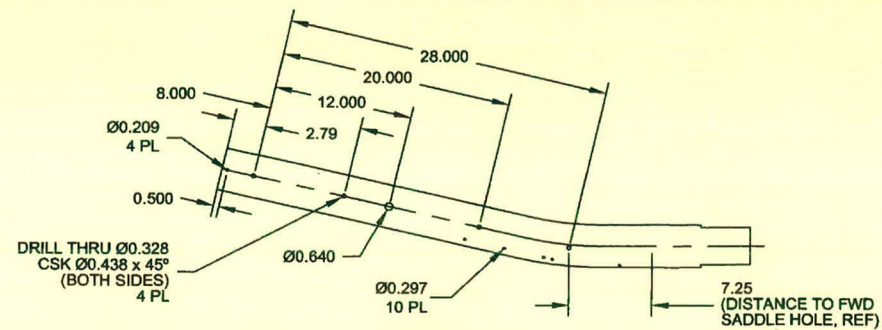
D3401-041
TOW CAP

AN3C4A BOLT
D3672-1 WASHER
NAS1149C0332R WASHER
4 PL

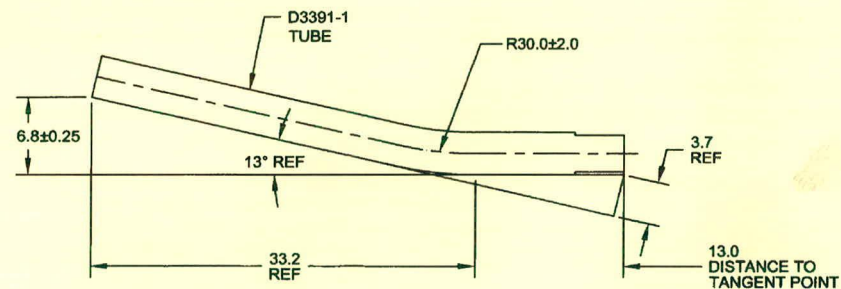
DETAIL B SCALE 2X

D3391-021 FWD TUBE ASSEMBLY PARTS LIST

QTY -021	PART NUMBER	DESCRIPTION
X	D3391-021	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
4	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER



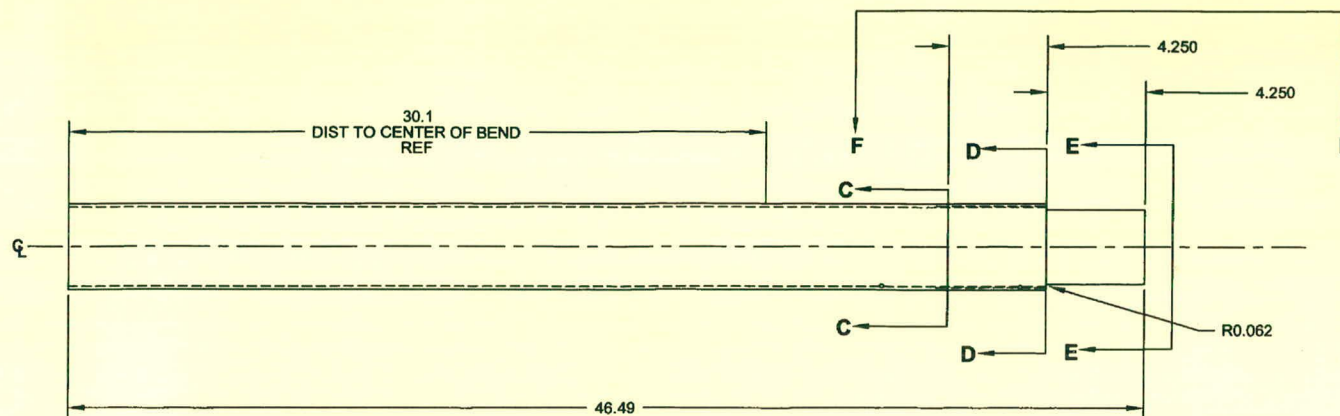
D3391-021 DRILLING DETAIL



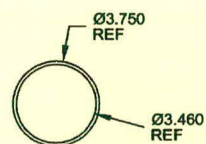
D3391-021 BENDING DETAIL (MAKE FROM D3391-1)

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2016-04-28

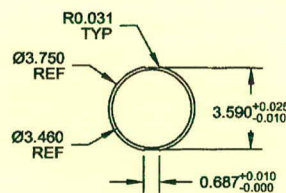
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DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	DR	D3391	SHEET 4 OF 11
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DE APPR.	#	412 FLOAT SKIDTUBE	NTS
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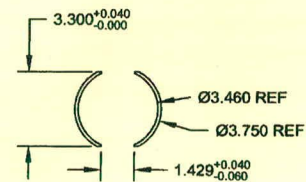
D3391-1 TUBE
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



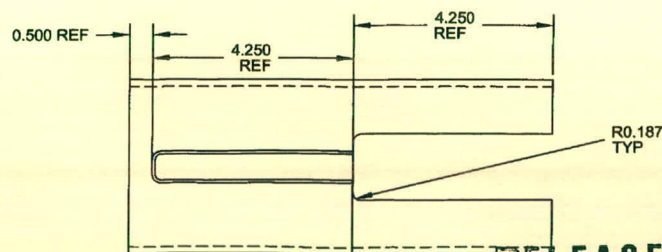
SECTION C-C



SECTION D-D



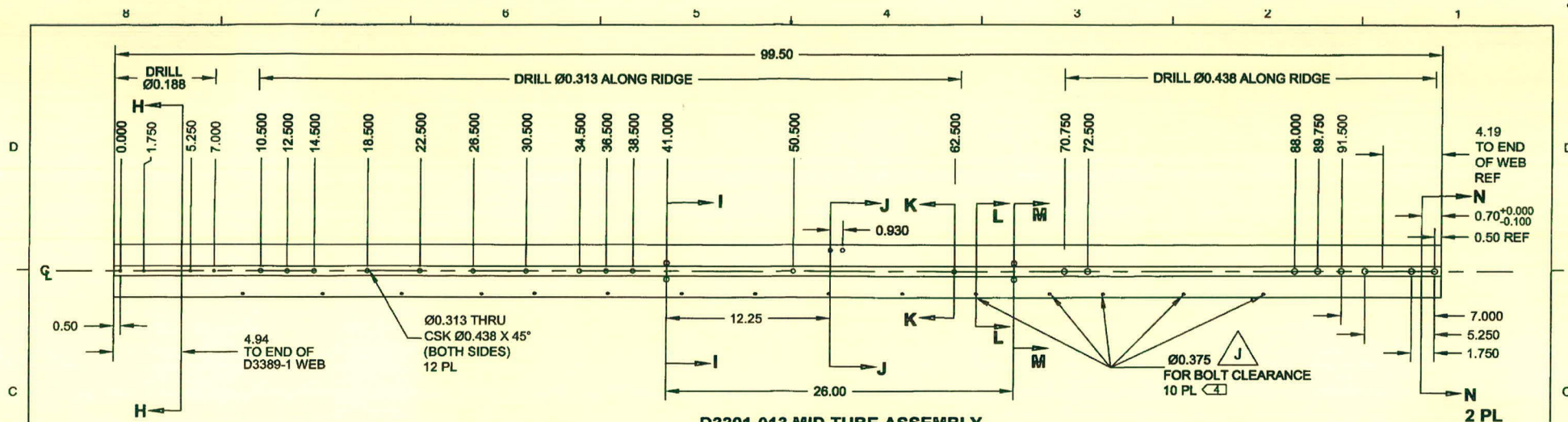
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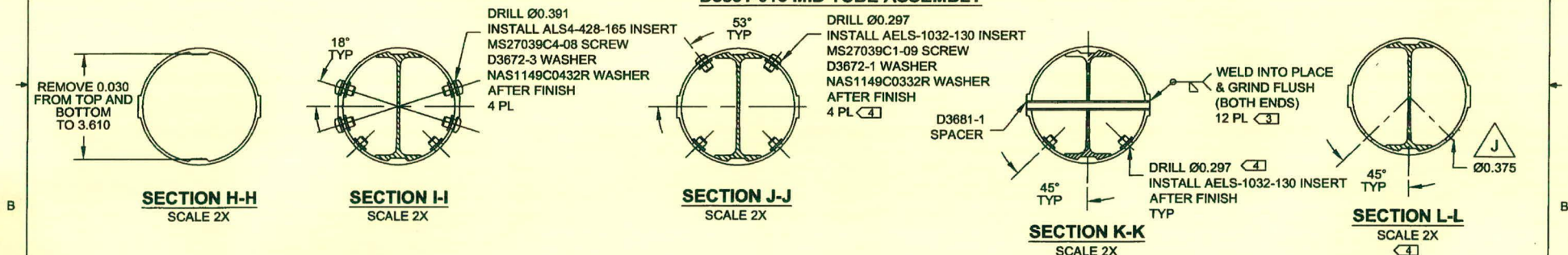
VIEW F-F
SCALE 2X

RELEASED
2016-04-28

DESIGN	PH	DART AEROSPACE USA, INC	
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CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.		D3391	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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D3391-013 MID TUBE ASSEMBLY



D3391-013 MID TUBE ASSEMBLY PARTS LIST

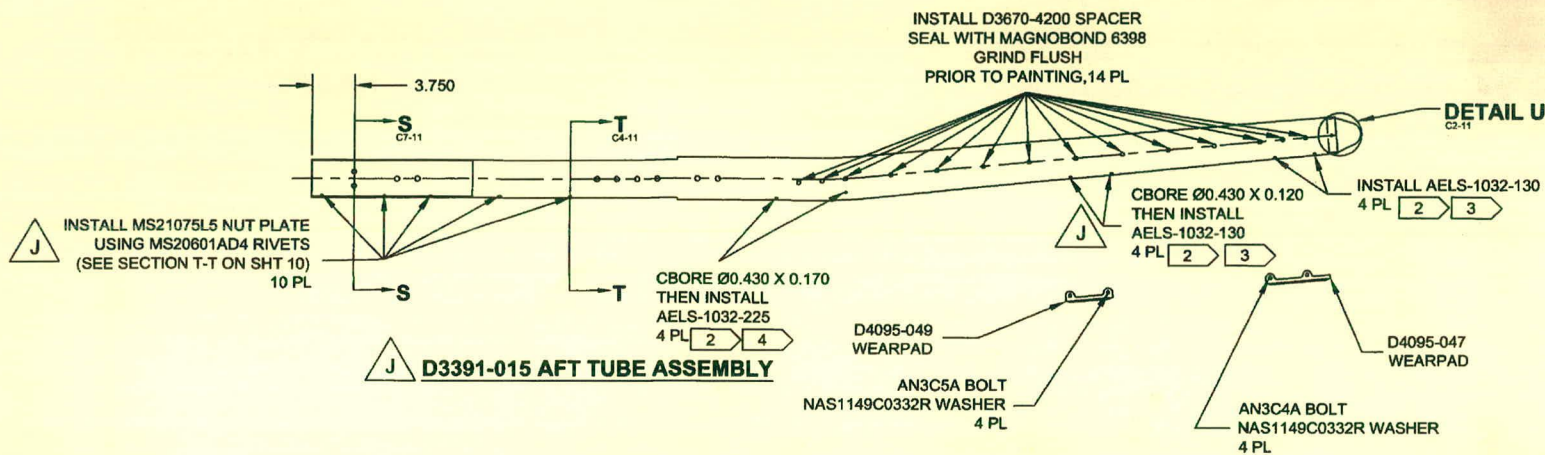
QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW
4	NAS1149C0332R	WASHER
4	NAS1149C0432R	WASHER

D3391-013 MID TUBE ASSEMBLY

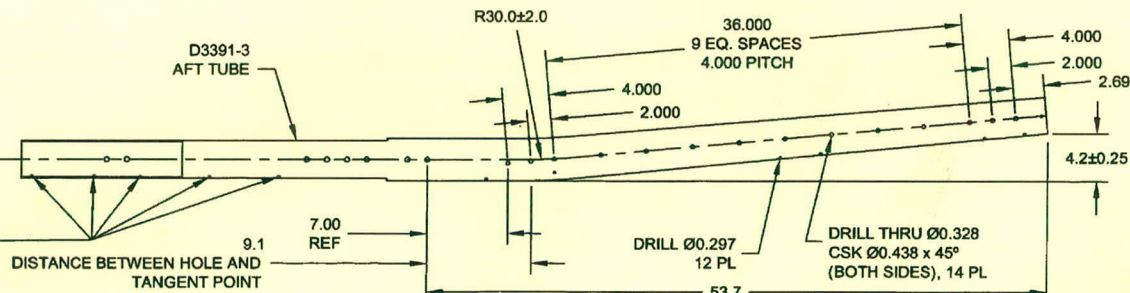
- 1) MATERIAL: MAKE FROM D2500-1-100
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORER AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV.
MFG. APPR.	<i>CP</i>	D3391	SHEET 6 OF 1
APPROVED	<i>CP</i>	TITLE	SCALE
DE APPR.	<i>CP</i>	412 FLOAT SKIDTUBE	NT
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DETAIL DD
B7-11 10 PL



D3391-015 AFT TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-016		
X	D3391-016	AFT TUBE ASSEMBLY
1	D2648	AFT CAP
1	D3391-3	AFT TUBE
14	D3670-4200	SPACER
2	D3672-1	WASHER
1	D4095-049	WEARPAD
1	D4095-047	WEARPAD
8	AELS-1032-130	INSERT
4	AELS-1032-225	INSERT
4	ALS4-428-165	INSERT
6	AN3C4A	BOLT
4	AN3C5A	BOLT
20	MS20601AD4	RIVET, BLIND
10	MS21075L5	NUT PLATE, FLOATING
10	NAS1149C0332R	WASHER

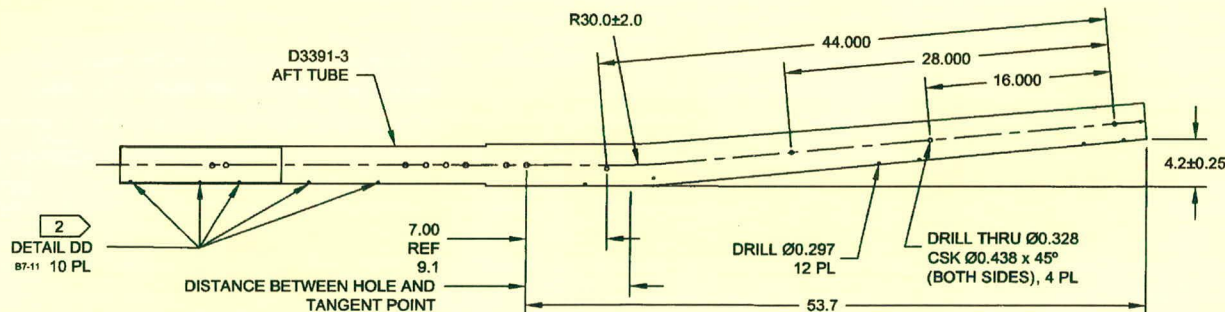
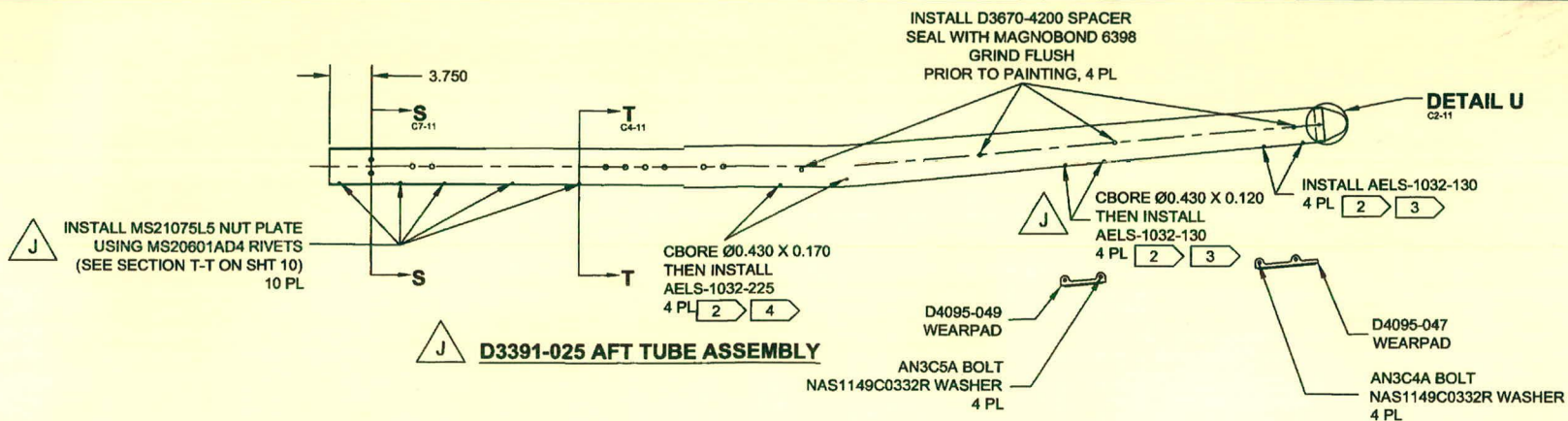
NOTES:

- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 2) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

BENDING AND DRILLING DETAIL

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D3391-025 AFT TUBE ASSEMBLY PARTS LIST

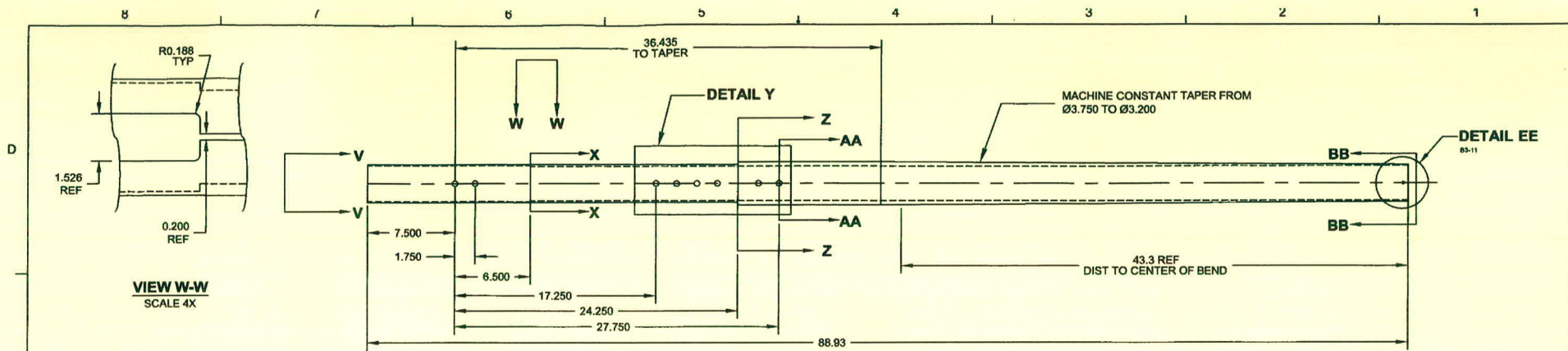
QTY	PART NUMBER	DESCRIPTION
X	D3391-025	AFT TUBE ASSEMBLY
1	D2846	AFT CAP
1	D3391-3	AFT TUBE
4	D3670-4200	SPACER
2	D3672-1	WASHER
1	D4095-049	WEARPAD
1	D4095-047	WEARPAD
8	AELS-1032-130	INSERT
4	AELS-1032-225	INSERT
6	AN3C4A	BOLT
4	AN3C5A	BOLT
20	MS20601AD4	RIVET, BLIND
10	MS21075L5	NUT PLATE FLOATING
10	NAS1149C0332R	WASHER

NOTES:

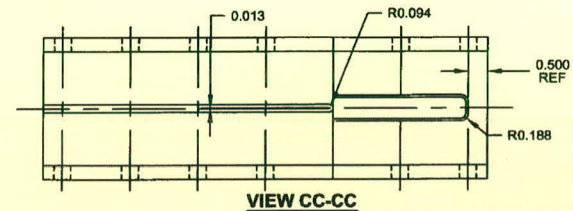
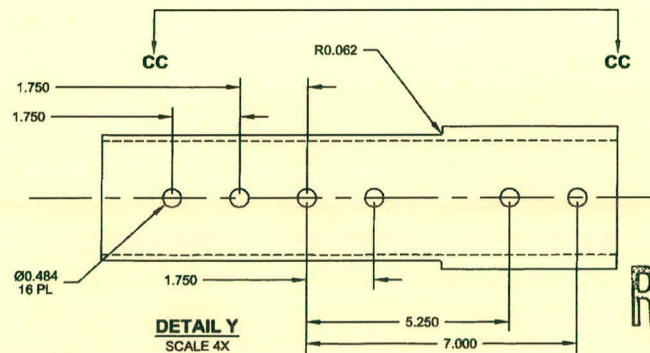
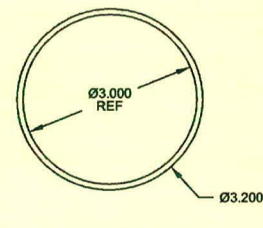
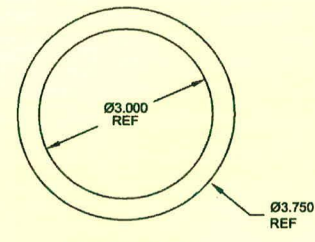
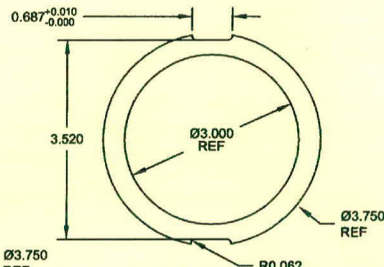
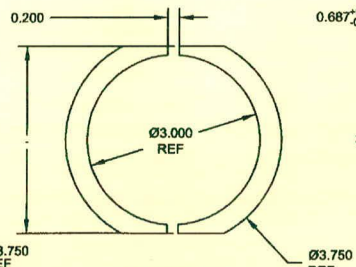
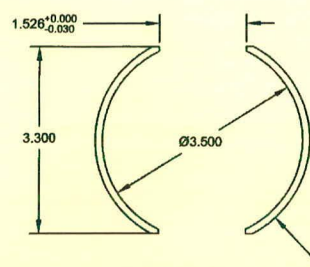
- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 2) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. C'BORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED. USE NUT PLATE DRILL JIG IF REQUIRED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

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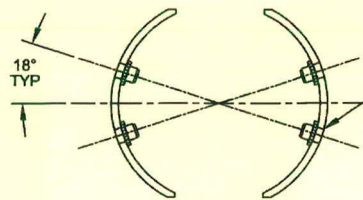


D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090)



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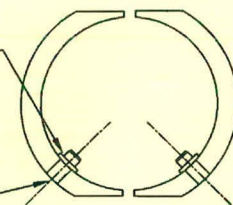


SECTION S-S
SCALE 5X
D6-8.9

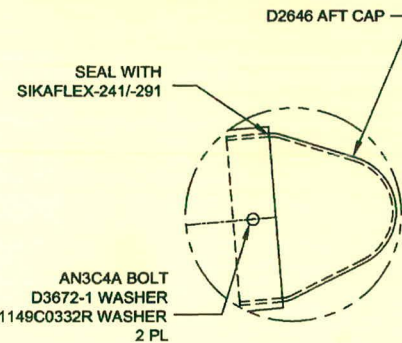
DRILL $\varnothing 0.391$
CBORE $\varnothing 0.516 \times 0.040$ DEEP
INSTALL ALS4-428-165 INSERT
4 PL

USE DT8217 DRILL TEMPLATE
TO LOCATE HOLES AND OPEN
TO $\varnothing 0.375$

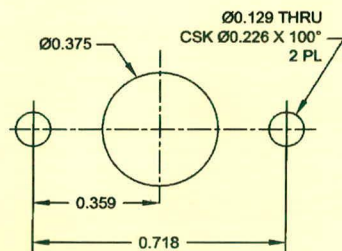
MS21075L5 NUTPLATE
REF



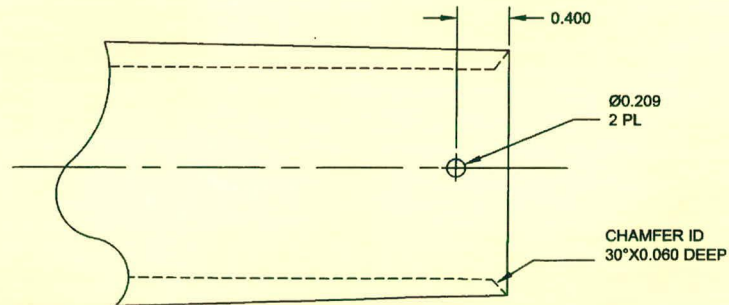
SECTION T-T
SCALE 5X
5 PL
D5-8.9
J



DETAIL U
SCALE 5X
D1-8.9



DRILLING DETAIL DD
SCALE 10X
B7-8.9
J



DETAIL EE
SCALE 2X
D1-11
J

NOTES:
1) USE INDUSTRY STANDARD NUT PLATE DRILL JIG IF REQUIRED.

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DE APPR.	CH	AFT TUBE ASSEMBLY	NTS
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